

Date: Monday, 6/19/2006 11:29:06 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 212/205 HIGH AFT X-TUBE ASSEMBLY
Job Number	: 27630		
Estimate Number	: 10257		
P.O. Number	: N/A	Part Number	: D212664201
This Issue	: 6/19/2006 S.O. No. : N/A	Drawing Number	: D212-664-241 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LANDING GEAR	Drawing Revision	: B
Previous Run	: 27629	Material	: N/A
Written By	: <u>SEGA COMMENT BELOW</u>	Due Date	: 7/18/2006
Checked & Approved By	: <u>KS 06.06.19</u>	Qty:	1 Um: Each
Comment	: Est Rev:E 04.02.16 Reformat K/DS Est Rev:F 06-03-29 Remove Coments on Pick List JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D212-664-201CHG002

KS 06.06.08

2.0	D6006129	Crosstube material
-----	----------	--------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D6006-129 Crosstube 23970

Check OD = 3.250"; ID = 2.220"

MS 06.06.26

3.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
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Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand &amp; install plugs DT8534 on both ends as per Folio FA114

2-Turn first side as per Folio FA114

3-Deburr &amp; Inspect for surface damage. Repair damage within limits as per Dwg D212-664-241. MS 06.06.26

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
-----	-----	------------------------------



Comment: INSPECT ALL DIM TO DIM SHEET

MS 06.06.26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA114

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-241.

MS 06/07/03 1

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

MS 06/07/03 1

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

MS 06/07/04 1

8.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Polish entire outside surface of crosstube

2-Remove sand and plugs

3-Scribe part # and batch # using vibrating stylus as per Dwg D212-664-241

MS 06/07/04 1

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1 within 24 hours of machining

FT 06-07-14

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

MS 06-07-14

11.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D212-664-241 using CNC bender program 212-af and Folio FT007

MS 06-07-14

W/O:		WORK ORDER CHANGES					
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Job Number: 27630

Part Number: D212664201

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

13.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube as per Dwg D212-664-241 using drill Jig DT8550 & DT8551

2-Ream hole to finish size in tube as per Dwg D212-664-241 using drill Jig DT8550 & DT8551. Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes.

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-241

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1 within 24 hours of bending and drilling

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

16.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038

Issue P/O: 1717

LPI as per ASTM 1417 Level 2

Attach copy of NDT results to work order

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage Ensure copy of NDT results attached to work order.

18.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK


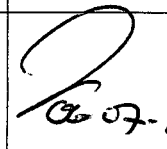
Inspect for damage & ensure results are as per Dwg D212-664-241

POSITIVE RECALL

EFFECTIVE 06-07-19 AUTH U

RELEASED 06-07-20 DATE U



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
06-07-21	18	QCS rec'd. Plan change		06-07-21			

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:  Date: 06/07/26

NOTE: Date & initial all entries

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## Process Sheet

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Job Number: 27630

Part Number: D212664201

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

FC 06 07 21 (1)  
MM 06 07 24 (1)

20.0

QC14

Inspect Spray Paint



Comment: Inspect Spray Paint

Then, Wrap in plastic bag to protect from scratches

IT 06-07-25 (1)

21.0

D2856600

Abrasion Strip



Comment: Qty.: 0.8400 f(s)/Unit Total: 0.8400 f(s)

Pick:

Qty Part number Description Batch

2 D2856-600-1009 Abrasion Strip B24328

IT 06-07-25

22.0

D29401

Support



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2940-1 Support B25594

IT 06-07-25

23.0

MS2192028

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-28 Clamp M100479

IT 06-07-25

24.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips as per QSI 035 using DT8582

IT 06-07-25

2-Install supports and clamps as per Dwg D212-664-241. Torque clamps to 80-100 in lb.

IT 06-07-25

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Part Number: D212664201

Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

26.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

27.0

D34281

Placard



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Placard

Batch: B26018 ✓

28.0

AN640A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

Batch: M101124 ✓

29.0

AN641A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bolt

Batch: M19633 ✓

30.0

AN960JD616

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total: 18.0000 Each(s)

Washer

Batch: M100324 ✓

31.0

MS21042L6

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)

Nut

Batch: M100151 ✓

26/7/25 (1)

W/O:		WORK ORDER CHANGES					
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Job Number: 27630

Part Number: D212664201

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

*AL 06/07/26 ①*

33.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Identify and pack for shipping as per PPP D212-664-201

*Rev B 6/17/26 ①*

34.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*06/07/26 ①*

Job Completion



*KJ 06.07.26*

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 27630
<b>Description:</b> Crosstube Assembly (205/212 High Aft)		<b>Part Number:</b> D212-664-241
<b>Inspection Dwg:</b> D212-664-241 <b>Rev:</b> B		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	0.200	+/-0.010	.200	✓			
	R0.063	+/-0.010	.063	✓			
	2.990	+0.005/-0.000	2.993	✓			
	5.237	+/-0.030	5.240	✓			
	2.600	+0.005/-0.000	2.602	✓			
	2.686	+0.005/-0.000	2.690	✓			
	2.770	+0.005/-0.000	2.775	✓			
	2.854	+0.005/-0.000	2.858	✓			
	2.938	+0.005/-0.000	2.942	✓			
	3.021	+0.005/-0.000	3.025	✓			
	3.133	+0.005/-0.000	3.138	✓			
	3.179	+0.005/-0.000	3.184	✓			
SIDE B	0.200	+/-0.010	.200	✓			
	R0.063	+/-0.010	.063	✓			
	2.990	+0.005/-0.000	2.992	✓			
	5.237	+/-0.030	5.240	✓			
	2.600	+0.005/-0.000	2.604	✓			
	2.686	+0.005/-0.000	2.690	✓			
	2.770	+0.005/-0.000	2.774	✓			
	2.854	+0.005/-0.000	2.858	✓			
	2.938	+0.005/-0.000	2.942	✓			
	3.021	+0.005/-0.000	3.025	✓			
	3.133	+0.005/-0.000	3.137	✓			
	3.179	+0.005/-0.000	3.183	✓			
	124.36	+/-0.020	124.36	✓			

<b>Measured by:</b> MS	<b>Audited by:</b> JML	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 06/07/03	<b>Date:</b> 06/07/04	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.27	New Issue (P/O D412-664-201)	KJ/JLM	
B	06.03.09	Tolerance for 5.237 was +/-0.001	KJ/JLM	



DESIGN PH	DRAWN BY PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D212-664-241	REV. B SHEET 1 OF 3
DATE 05.02.04		TITLE CROSSTUBE ASS'Y (205/212 HI AFT)	SCALE NTS
A	00.12.12	NEW ISSUE	
B	05.02.04	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	

RELEASED  
05.06.09 [Signature]

Qty	Part Number	Description
X	D212-664-241	CROSSTUBE ASSEMBLY (205/212 HIGH AFT)
1	D6006-129	CROSSTUBE
2	D2940-1	SUPPORT
2	D2856-600-1009	ABRASION STRIP
4	MS21920-28	CLAMP

#### GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) MATERIAL: MANUFACTURED FROM D6006-129  
FINISHED LENGTH =  $124.36 \pm 0.020$
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 5 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-600-1009 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2940-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) IT IS OPTIONAL TO SEAL EDGES OF SUPPORTS AND ABRASION STRIP USING SIKAFLEX-241/291 SEALANT.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

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WITHOUT NOTICE  
WORK ORDER  
NO. 27630

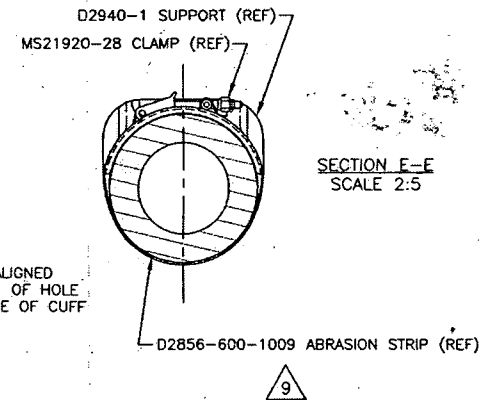
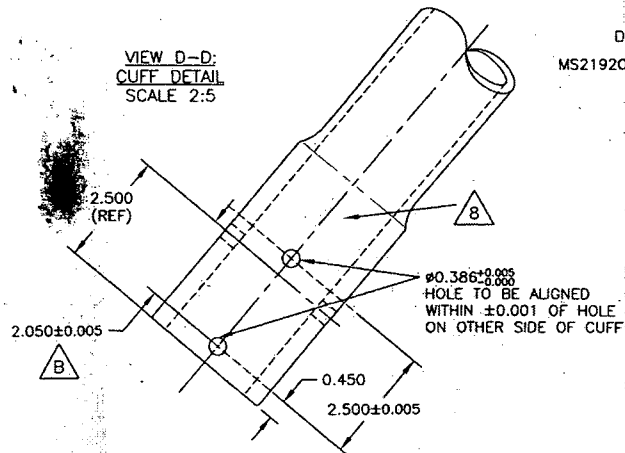
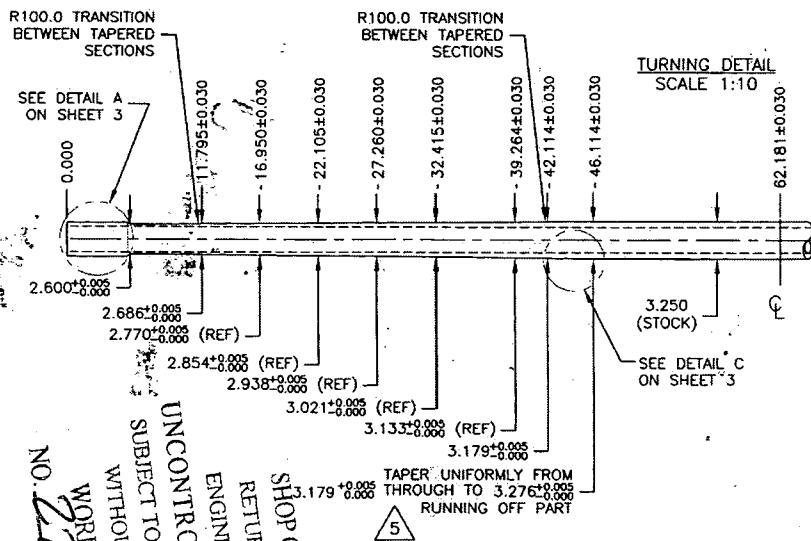
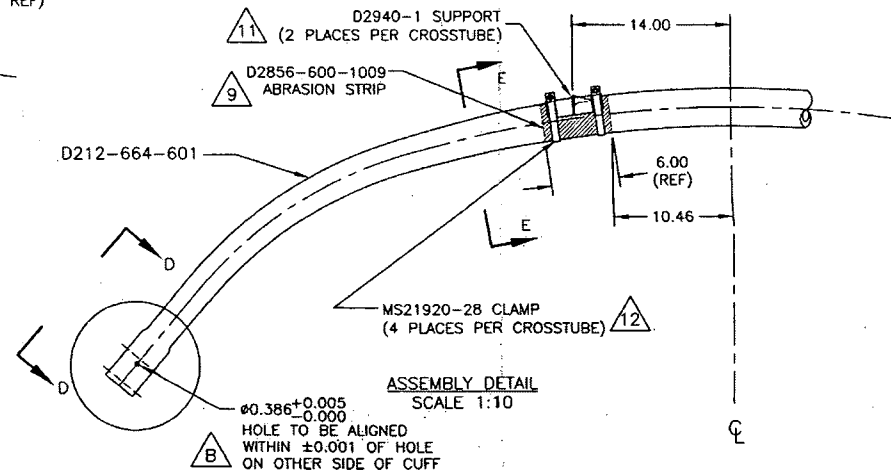
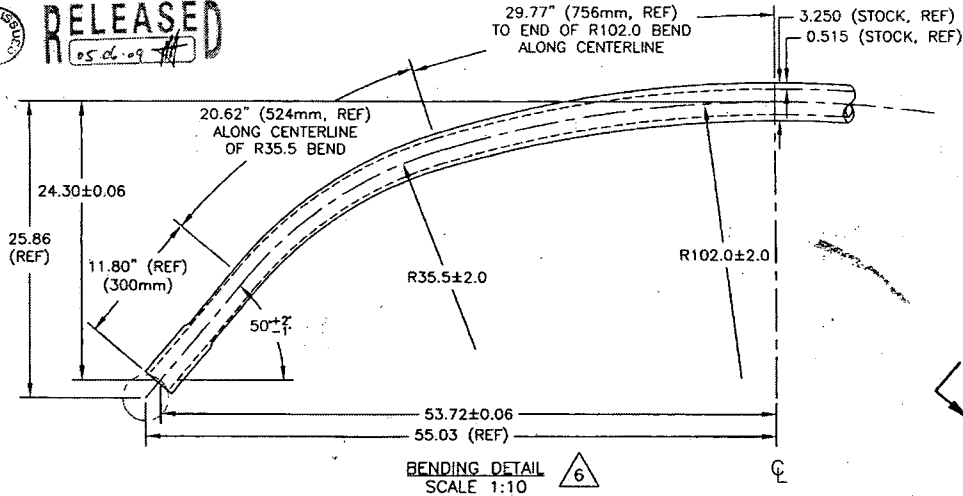
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RELEASED  
05.02.04



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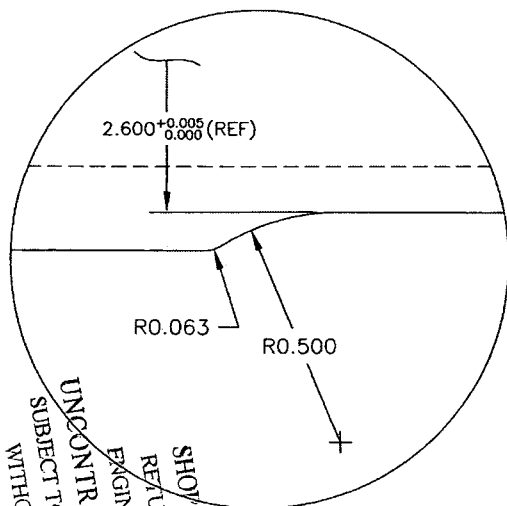
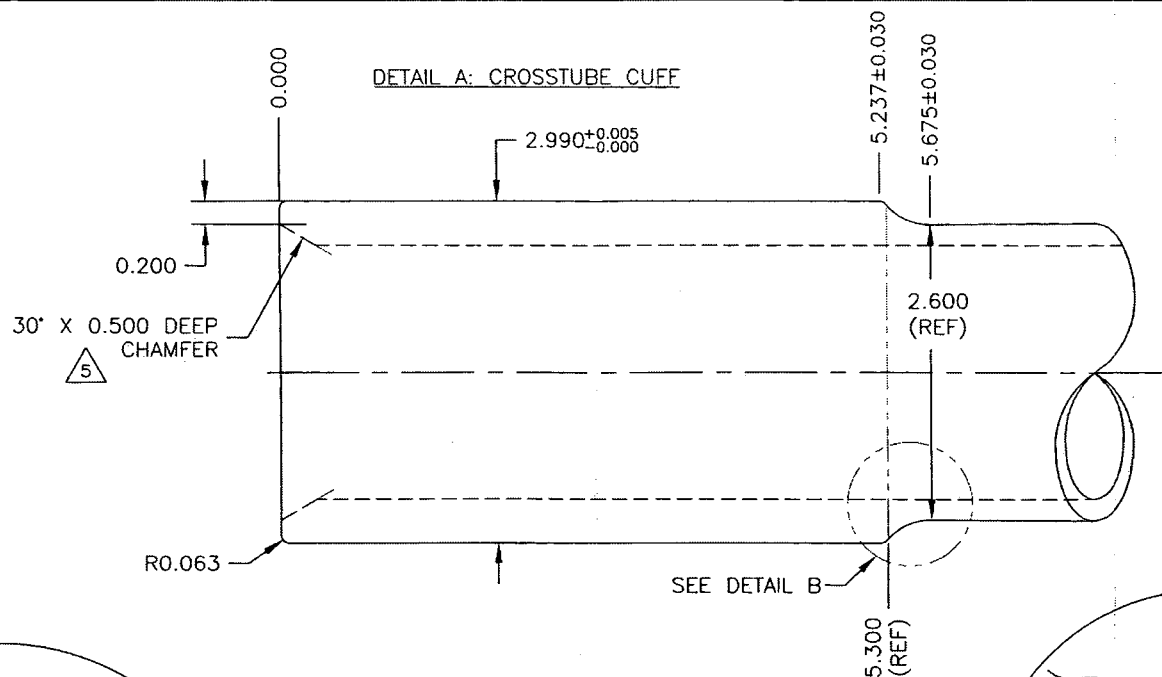
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DESIGN	PH	DRAWN BY	PH	<b>DART</b>	DART AEROSPACE LTD. WARRICKSURY, OXFORD, ENGLAND
CHECKED	PH	APPROVED	PH	DRAWING NO.	REV. B
				D212-664-241	SHEET 2 OF 3
DATE	05.02.04	TITLE		CROSSTUBE ASS'Y (205/212 HI AFT)	SCALE 1:10

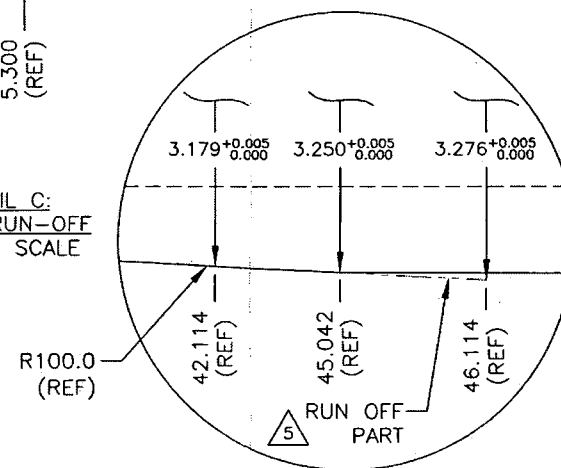
NO. 27630  
WORK ORDER  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY  
NO. 27630



RELEASED  
05-06-09

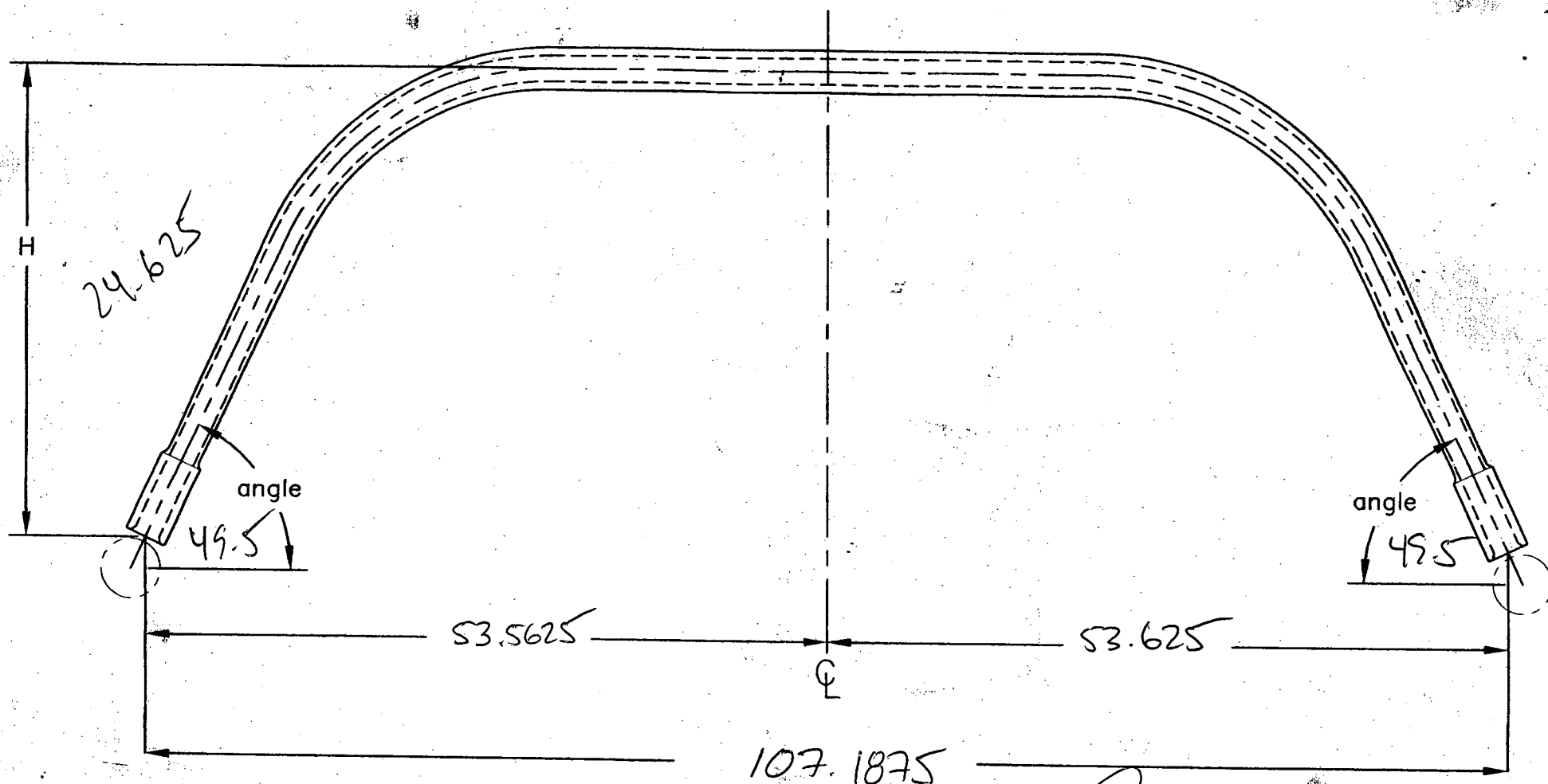


DETAIL C:  
TAPER RUN-OFF  
NOT TO SCALE



NO. 27630  
WORK ORDER  
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		DATE		D212-664-241	SHEET 3 OF 3
		05.02.04		TITLE	SCALE
				CROSSTUBE ASS'Y (205/212 HI AFT)	1:1



DATE: 06-07-19

DESCRIPTION: 212-664-201

BATCH NO: B27630

DRAWING: 212-664-241 R-B

H: 24.30 }  $\pm .06$

1/2 SPAN: 53.72

TOTAL SPAN: 107.44

ANGLE: 50<sup>th</sup>

**L Lacelle**

---

**From:** David Shepherd [dshepherd@dartaero.com]  
**Sent:** July 20, 2006 10:43 AM  
**To:** 'Jason Murdoch'  
**Cc:** 'L Lacelle'  
**Subject:** RE: scan

D212-664-201 B27630 is acceptable.

---

**From:** Jason Murdoch [mailto:jmurdoch@dartaero.com]  
**Sent:** Thursday, July 20, 2006 3:55 AM  
**To:** davids@dartaero.com  
**Subject:** FW: scan

Good morning Davey Boy. Is this one ok????

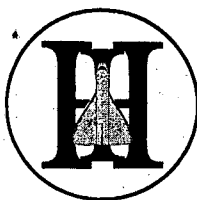
[jmurdoch@dartaero.com](mailto:jmurdoch@dartaero.com)

**Q.C.Inspector**

---

**From:** Brigitte Golden [mailto:bgolden@dartaero.com]  
**Sent:** July 19, 2006 11:42 AM  
**To:** jmurdoch@dartaero.com  
**Subject:** scan

Brigitte Golden  
Order Processing  
Dart Aerospace Ltd.  
[bgolden@dartaero.com](mailto:bgolden@dartaero.com)



# HeathAir

INTERNATIONAL (1991) INC.

681 Ave. Lepine, Dorval, Québec H9P 1G3  
Tél.: (514) 636-1000 • Fax: (514) 636-0031

W.O. N° 34517

A.M.O. Number: 46/90

## NON-DESTRUCTIVE TESTING REPORT

### AIRCRAFT / COMPONENT INFORMATION

REGISTRATION: -

MODEL/TYPE: -

SERIAL NUMBER: -

TOTAL HR/LDG: -

OPERATED BY: -

BASED AT: -

### INSPECTION REQUIREMENTS

Carry out FPI of (4) cross tubes (external surface) as per ASTM E-1417-05 and the Dart QSI 038, Section 4.1.1 (on file at client) - parts delivered to HeathAir.

Qty (2) P/N D212-664-201 Cross tubes S/N's B27630 and B26320.  
Qty (2) P/N D412-664-203 Cross tubes S/N's B27389 and B27261.

☐ RADIOGRAPHY

☐ ULTRASONIC

☒ PENETRANT

☐ MAGNETIC PARTICLE

☐ EDDY CURRENT

### INSPECTION REPORT

Fluorescent penetrant inspection was performed in accordance with the above requirements on (4) Cross Tubes.

Note: A Level 3 penetrant was substituted for the requested Level 2 (3 is more sensitive) Ardrex 970P25E Batch #04B503.

(4) cross tubes inspected. (4) PASSED inspection / (0) FAILED inspection.

THE MAINTENANCE DESCRIBED ABOVE HAS BEEN PERFORMED IN ACCORDANCE WITH  
THE APPLICABLE STANDARDS OF AIRWORTHINESS

INSPECTED BY: 

DATE July 19, 2006

INSPECTION  
STAMP(S): 

### CUSTOMER INFORMATION

CUSTOMER: Dart Aerospace

P.O. NUMBER 1717

ADDRESS:

CONTACT NAME: Linda

LABOUR @

\$

MATERIALS @

TRAVEL EXPENSES @

GST

HOTEL EXPENSES @

PST

INVOICE NO. 

TOTAL \$ 

WHITE COPY - INSPECTION FILE • YELLOW COPY - CUSTOMER • PINK COPY - ACCOUNTANT